



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23006783
Job Sheet 187631



Part No: RB23006783

Job Qty: 18 ea

Part Name: Adapter, Torque Turbine Attach Upper Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg. RB23006783 Rev.A IPP Rev.A 18.01.19 New Issue JFS Verify by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Large Fab-7		
95	Handfinish -7-1-BeadBlast-B4B	18 pcs	12/21/18	12/21/18	0.00	2.25	Handfinish - 7 - 1 - B4B		
100	Large Fab	18 pcs	12/21/18	12/21/18	0.08	1.80	Large Fab 8		
110	QC	18 pcs	12/21/18	12/21/18	0.00	0.00	QC9		
120	QC	18 pcs	12/21/18	12/21/18	0.00	0.00	QC5		
125	Outsource - 12 - Black Oxide	18 pcs	12/21/18	12/21/18			GRO002-VC		
126	Packaging 2-1 - Receive - B4B	18 pcs	12/21/18	12/21/18	0.00	0.00	Packaging 2 - 5 - B4B		
128	QC 6	18 pcs	12/21/18	12/21/18	0.00	0.00	QC 6 - 16 38 38 9-89		
130	Packaging	18 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-2		
140	QC21-FG	18 Ea	12/21/18	12/21/18	0.00	0.00	QC21		

Part Op 95 - Bead blast remove all chrome.

Descriptions: 100 - 1- Manufacture RB23006783-1 as per dwg. 2- Weld square drive as per dwg. 3- Polish weld

125 - -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool Steel -Certificate of Conformity is required
130 - IDENTIFY AND STOCK

PO Details

Metec Metal Technology Inc. (mem001-vc)



PO No: PO042037

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
FS101	Snap-On, Shallow Socket	18 Ea (1 ea)	90-Start up Operation	
XS1214	Snap-On 3/8-7/16 Short, 10° Offset Bex Wrench	18 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	FS101	18	11	0
	XS1214	18	0	0

Part Specifications

Specifications could not be found.

Plex 12/18/18 1:34 PM Dart.Gagnon.Michelle



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Status: New

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Job Tracking No:

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Type: SOLD

Description:

Note: Dwg. RB23006783 Rev.A IPP Rev.A 18.01.19 New Issue JFS Verify by: DP

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Bill of Materials

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		12/21/18	0.00	0.00	Start Up Large Fab-7		EL
95	Handfinish -7-1-BeadBlast-B4B	18 pcs		12/21/18	0.00	2.25	Handfinish - 7 - 1 - B4B		BEB/8-12-10
100	Large Fab	18 pcs		12/21/18	0.08	1.80	Large Fab 8		EL 12-11-18
110	QC	18 pcs		12/21/18	0.00	0.00	QC9		SL
120	QC	18 pcs		12/21/18	0.00	0.00	QC5		SL
130	Packaging	18 pcs		12/21/18	0.00	0.00	Packaging3-2		
140	QC21-FG	18 Ea		12/21/18	0.00	0.00	QC21		

Part Op 95 - Bead blast remove all chrome.

Descriptions: 100 - 1- Manufacture RB23006783-1 as per dwg. 2- Weld square drive as per dwg. 3- Polish weld
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
FS101	Snap-On, Shallow Socket	18 Ea (1 ea)	90-Start up Operation	
XS1214	Snap-On 3/8-7/16 Short, 10° Offset Bex Wrench	18 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	FS101	18	29	0
			18	0



Container No: S136414



Part: RB23006783

Job No: 187631

Serial No/Batch: S136414

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

found.

Plex 12/10/18 2:19 PM Dart.lajeunesse.marie

Date: 12/10/18

Entered: _____ Date: _____

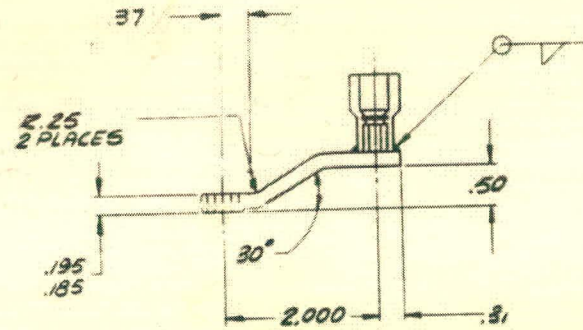
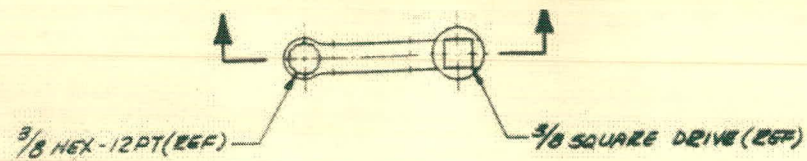


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



SECTION A-A
WELDMENT

2	1	SOCKET	55719	F5101 (3/8 DRIVE)	SNAP-ON TOOL
1	1	WRENCH	55719	X51214 (3/8)	SNAP-ON TOOL
ITEM NO.	NO. REQD.	NOMENCLATURE OR DESCRIPTION	CODE IDENT.	PART OR IDENTIFYING NO.	MATERIAL OR NOTE
FOR PART IDENTIFICATION ITEM NUMBERS ARE EXPRESSED AS DASH NUMBERS. THIS BASIC DRAWING, EXCEPT WHERE A NUMBER APPEARS IN THE PART OR IDENTIFYING NUMBER COLUMN.					

ADAPTER-TORQUE TUBE ATTACH NUT, UPPER			
MODEL	SIZE	CODE	APPLICATION SEE SEPARATE PARTS LIST
D	73342	23006783	
SCALE 1/1			SHEET OF

FINISH: BLACK OXIDE

FS101

116283 x 2

121937 x 6

133812 x 10

FS1214



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PURCHASE ORDER **PO042037**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042037

PO Date: 12/12/18

Due Date: 12/18/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: * Bring straight to JL or Jason before bringing to QC*

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187631	RB23006783			Adapter, Torque Turbine Attach Upper Nut -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool Steel -Certificate of Conformity is required	Firmed	-	12/18/18	18 pcs	0 pcs	18 pcs	\$5.00/pcs	\$90.00
Grand Total:												\$90.00	

DAS
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18 X DEC 17 2018



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PURCHASE ORDER PO042037

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "dh" or similar, located to the right of the terms and conditions text.

Plex 12/14/18 9:18 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24382
Shipment Date: 13-Dec-2018
Ship Via: Pick up at METEC
Order Number: 3294
Order Date: 12/12/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042037
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	1	1	0	0	LOT	BLACK OXIDE TREATMENT 18 parts		3294-01

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The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By

